

Date: Monday, 11/05/2009 1:39:45 PM
 User: Julie Dawson

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|--------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | GUSSET ASS'Y |
| Job Number : | 47881 | | |
| Estimate Number : | 13866 | | |
| P.O. Number : | | Part Number : | D3929042 |
| This Issue : | 11/05/2009 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3929 REV A |
| First Issue : | / / | Project Number : | N/A |
| Previous Run : | 47558 | Drawing Revision : | A |
| Written By : | | Material : | |
| Checked & Approved By : | <u>JUD 09-05-11</u> | Due Date : | 28/05/2009 |
| Comment : | Est Rev:A 09-04-20 new issue EC verified by:DD | | |

Qty: 6 Um: Each

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|---------------------|
| 1.0 | M304S11GA | 304/316 0.125 Sheet |
|-----|-----------|---------------------|



Comment: Qty.: 0.4725 sf(s)/Unit Total: 2.8350 sf(s)

304/316 .125" Sheet

Batch: 11108 FB 9-5-15

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

FB 9-5-15

⑦

2-Deburr if necessary FB 9-5-15

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

FB 9-5-15

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

8 09/05/15 (x7)

| | | |
|-----|--------|---------|
| 5.0 | D39071 | Bushing |
|-----|--------|---------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Bushing

Batch: 347973

347973

14
CP 09.05.26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:39:45 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUSSET ASS'Y

Job Number: 47881

Part Number: D3929042

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld bushings D3907-1 as per dwg D3929

316L rod batch: m106762

PC 09-05-26

(47)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-05-26 (7)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/26

(47)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify as per dwg and Stock

Location: Basket

PD 09-05-26 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/27 MF

Job Completion



MF
09-05-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

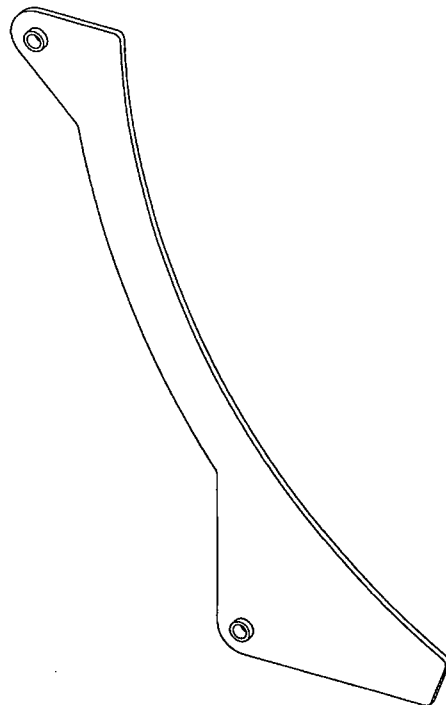
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

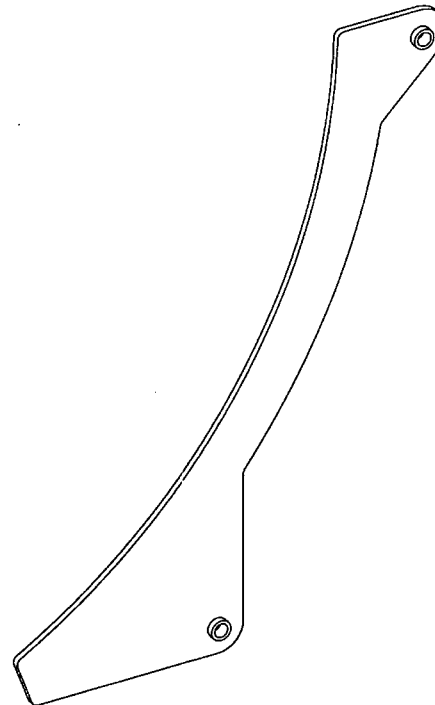
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | QTY -042 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|-----------------|
| 1 | X | | D3929-041 | GUSSET ASSEMBLY |
| 2 | | X | D3929-042 | GUSSET ASSEMBLY |
| 11 | 2 | 2 | D3907-1 | BUSHING |
| 12 | 1 | 1 | D3929-1 | SUPPORT GUSSET |



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
07/04/12 MD

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

| | | | |
|------------|-------------|----|----------|
| A | NEW ISSUE | MB | 09.04.03 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 09.04.03 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3929

TITLE
GUSSET ASSEMBLY

REV. A
SHEET 1 OF 3

SCALE
NTS

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| | | |
|---------------------------|---------------------|--------------------|
| DART AEROSPACE LTD | Work Order: | 47881 |
| Description: | Part Number: | D3929-G42 |
| | | |
| Inspection Dwg: | Rev: | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

114

Prototype

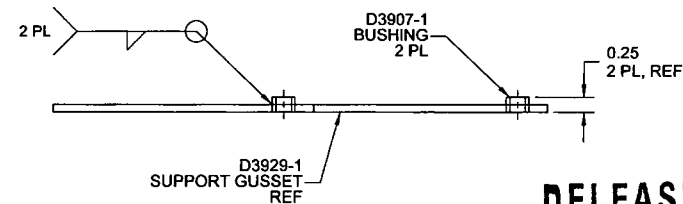
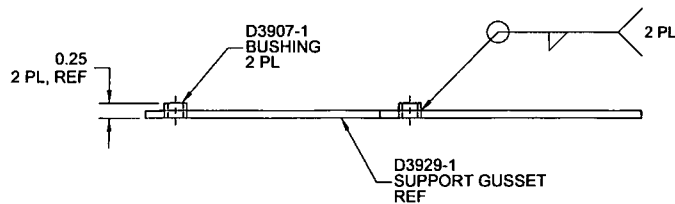
[illegible]

| | | | | | |
|--------------|--------|-------------|----------|---------------------|----|
| Measured by: | IB | Audited by: | S | Prototype Approval: | 2/ |
| Date: | 9-5-15 | Date: | 01/05/15 | Date: | 1/ |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |

D3929-1
SUPPORT GUSSET
2 PL

D3929-1
SUPPORT GUSSET
2 PL



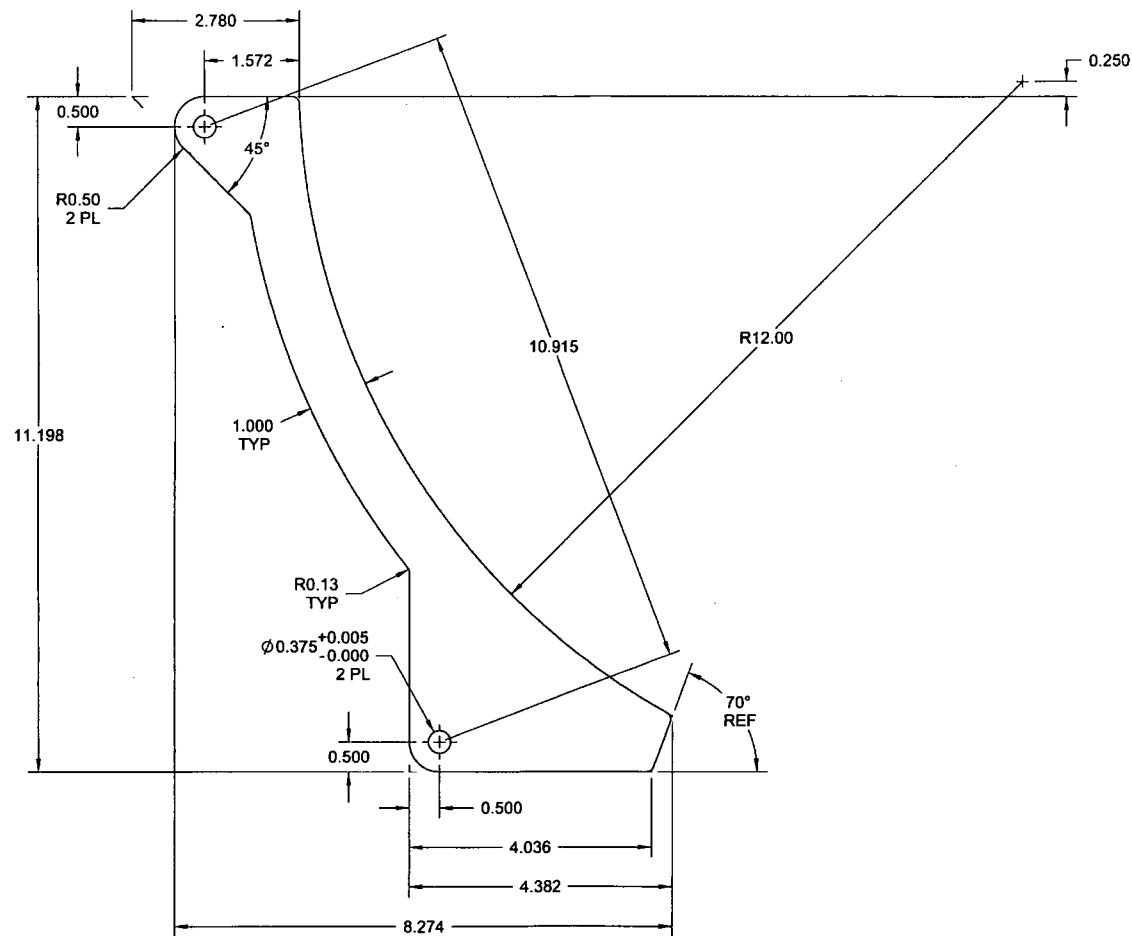
D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
9/14/22

| | | | |
|------------|----------|--|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3929 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | GUSSET ASSEMBLY | NTS |
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WHICH A NOTICE



D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

| | | |
|------------|-----------------|--|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. D3929 REV. A |
| MFG. APPR. | | SHEET 3 OF 3 |
| APPROVED | | TITLE GUSSET ASSEMBLY SCALE NTS |
| DE APPR. | | |
| DATE | 09.04.03 | |

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